User: Customer **Job Number Estimate Number** P.O. Number This Issue Prsht Rev. First Issue **Previous Run** Written By Checked & Approved By Comment Job Number: Seq. #: 1.0 2.0

**Process Sheet Drawing Name** 

Part Number

**Drawing Number** 

Chantal Lavoie : CU-DAR001 Dart Helicopters Services : 28646 : 10009 : NA : 9/19/2006 S.O. No. : W/A : SMALL /MED FAB : 28646

waterjet

: Est Rev:C Removed from 9 Digit

05-10-25 JLM 06.09.19 EC

Project Number : N/A **Drawing Revision** :NA Material : 9/26/2006 Um: Each **Due Date** 

: LUG BRACKET

: D27351.

: D2735 REV C

**Additional Product** 

est rev D

Tuesday, 9/19/2006 11:03:35 AM

Description: **Machine Or Operation:** M1010S125 1010-1025 sheet .125

6.9300 sf(s) Comment: Qty.; 0.1733 sf(s)/Unit Total:

> 1010-1025 sheet .125 batch: M 15925

**Comment: FLOW WATER JET** 1-Cut as per Dwg D2735 (D2735-1)

Dwg Rev: C Prog Rev: C

2-Deburr if necessary INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE 4.0

Comment: SECOND CHECK BRAKE NC 5.0

Comment: NC BRAKE

1-Form D2735-1 as per Dwg D2735. Use CNC Brake Jig DT8204

2-Deburr if required.

06/16/03

3.0

### **Dart Aerospace Ltd**

Dail AC	lospace	Llu							
W/O:			WC	RK ORDER CHANG	ES				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									-
Part No	:	PAR #:	Fault Cateç	jory:	•				
· · · · · · · · · · · · · · · · · · ·							:	Date: _	
NCR:		,	WORK ORDE	R NON-CONFORMA	NCE (NCR	)			
		Description of NC		Corrective Action Section	on B	Verifica	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sectio		Chief Eng	QC Inspector
1									

NOTE: Date & initial all entries

Pate:

Tuesday, 9/19/2006 11:03:36 AM

£\ser:

Chantal Lavoie

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

**Drawing Name: LUG BRACKET** 

Job Number: 28646

Part Number: D27351

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

6.0

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PACKAGING 1

PACKAGING RESOURCE #1

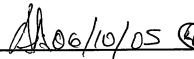


**Comment: PACKAGING** 

Identify and Stock Location: WS



8.0 QC21 FINAL INSPECTION/W/O RELEASE





Comment: FINAL INSPECTION/W/O RELEASE



Job Completion



U do 10-05

## Dart Aerospace Ltd

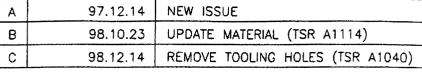
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W/O:			WC	RK ORDER CHA	NGES					
DATE	STEP	PR	OCEDURE CHAI	NGE	By Date Qty Chi			Approval Chief Eng / Prod Mgr	proval ef Eng / od Mgr Approval QC Inspector	
1111										
			· .							
Part No	:	PAR #:	Fault Categ	jory:	NCR: Y	es N	o <b>DQ</b> /	 <b>A:</b>	Date:	
	-								Date: _	
NCR:			WORK ORDE	R NON-CONFOR	RMANCE (N	CR)				
DATE	STEP	Description of NC	Corrective Action Section B			VARITICATION   An			Approval	Approval
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng		n & ate	Secti		Chief Eng	QC Inspector
		*								
1										-

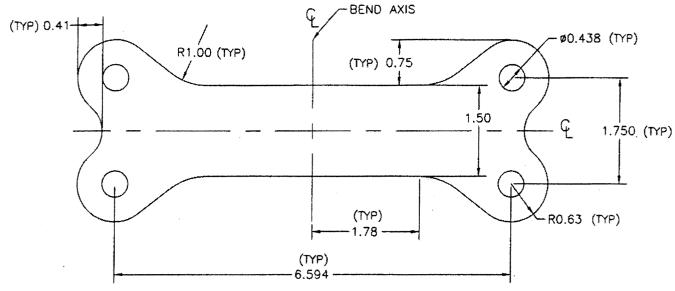
NOTE: Date & initial all entries



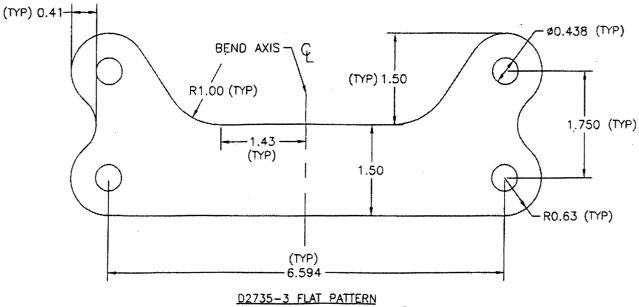


DESIG	4	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHEC	KED	APPROVED KE	DRAWING NO. REV. C
	1	RE	D2735 SHEET 1 OF 2
DATE			TITLE SCALE
98.1	12.14		LUG BRACKET 2:3
Α		97.12.14	NEW ISSUE
В		98.10.23	UPDATE MATERIAL (TSR A1114)
C		98 12 14	REMOVE TOOLING HOLES (TSR A1040)





#### D2735-1 FLAT PATTERN SYMMETRIC ABOUT BOTH CENTRE-LINES (G)

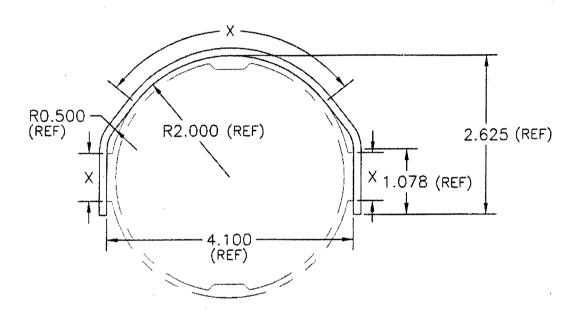


SYMMETRIC ABOUT CENTRE-LINE (4)



DESIGN	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CANAG			
CHECKED	APPROVED KE	DRAWING NO. D2735	SHEET	REV. 2 OF	-
DATE		TITLE		SCA	U.E
98.12.14		LUG BRACKET		2	2:3





D2735-1 AND D2735-3 BEND DETAIL D2735-1 AND D2735-3 SHOULD BE BENT TO WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2500-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

#### **GENERAL NOTES**

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL

0.125 THICK (11 GAUGE) MIN. ULTIMATE TENSILE STRENGTH = 42 ksi MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE IN INCHES

DART AEROSPACE LTD	Work Order:	28646
3.3	 Part Number:	2735-1
Description: **	Part Number:	A/JJ
Inspection Dwg: \\Rev:		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	X	Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0 0 438	+1-0.005,0.000	0.438	1	138.3	Vern	
1.750	H- 0.010	1.752	<b>V</b>		VerN	·
150	+1-0.030	1.51	V		vern	
0.41	+1-0.030	0.39			AFKN	
6.594	4/-0010	6.590	. √		yers "	
RO.63	+1-0.030	RO.63	<b>/</b>		Radius G	ungo
RO.1.00	+1-0.010	RO 1.00	1		RADIUS GB	nge
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Measured by: M	Audited by:		Prototype Approval:	
Date: 05 09 20	Date:	00:05-25	Date:	

				Revised by	Approved
∣ R	ev	Date	Change		7.45
	A		New Issue	KJ/JLM	i

